

Work Order ID 133859

Monday, June 22, 2015 10:14:03 AM

133859

Page 1

Item ID: D412-698-019 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bearing Overhaul
Start Date: 6/22/15 Start Qty: 2.00 *?
Required Date: 6/22/15 Req'd Qty: 2.00 *?
Cust Item ID:
Customer:
Reference:

Approvals: Process Plan:  Date: 15.6.22 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-698	Rev E								
100	Document Control	0.00							
100	DOCUMENT CONTROL								DAS 02 9-89
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD412-698-019		CHG001						JUN 22 2015
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									DAS 27 9-89 JUN 22 2015
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									DAS 9 9-89 JUN 22 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																								
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearing Overhaul

Start Date: 6/22/15 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/22/15 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-698-019
Location:FG023

Ship MF 15-6-22

140

0.00

140

QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

MCJ JUN 22 2015

MF 15-6-22

DQA: _____ Date: _____



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Picklist Print

Monday, June 22, 2015 10:14:08 AM

Page 1

Work Order ID: 133859

133859

Parent Item: D412-698-019

D412-698-019

Parent Item Name: Bearing Overhaul

Start Date: 6/22/15

Required Date: 6/22/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:B 05-10-12 Pick List Revised KJ/JLM
IPP Rev:C 08-01-28 change to rev D ECN 1104 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-21		Manufactured	No			110	Each	47.0000	7	14			
D3121-21									**				
Bolt	DAS 02 9-89	DAS 9 9-89										DAS 27 9-89	DAS 01 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST018				47					
				129690				27		14			
				132416				20					
D3121-241		Manufactured	No			110	Each	29.0000	5	10			
D3121-241									**				
Bearing Assembly	DAS 02 9-89	DAS 9 9-89										DAS 27 9-89	DAS 01 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				FG				14					
				89826				4					
				95927				10					
				ST019				15					
				128510				1					
				132739				14		10			
D3137-3		Manufactured	No			110	Each	19.0000	1	2			
D3137-3									**				
Guide	DAS 02 9-89	DAS 9 9-89										DAS 27 9-89	DAS 01 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST020				19		2			
				128584				4					
				132394				15					

JUN 22 2015

DQA: _____ Date: _____



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Picklist Print

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Page 2

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133859

Parent Item: D412-698-019

D412-698-019

Parent Item Name: Bearing Overhaul

Start Date: 6/22/15

Required Date: 6/22/15

Start Qty: 2.00

Required Qty: 2.00

D3137-5 Manufactured No

110 Each 17.0000 1 2

D3137-5

Washer

DAS
27
9-89

DAS
27
9-89

DAS
02
9-89
DAS
9
9-89

Location

Loc Qty

Loc Code

ST020

17

112733

6

129804

11

D3183-045 Manufactured No

110 Each 32.0000 2 4

D3183-045

Bearing Assembly

DAS
27
9-89

DAS
27
9-89

DAS
02
9-89
DAS
9
9-89

Location

Loc Qty

Loc Code

FG

5

133005

7

88587

5

ST025

20

133201

20

MS24694-S101 Purchased No

110 Each 77.0000 1 2

MS24694-S101

Screw

DAS
27
JUN 22 2015

DAS
27
9-89

DAS
02
9-89
DAS
9
9-89

Location

Loc Qty

Loc Code

ST288

77

M129909

77

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Shop Packet Print

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OTHER :					

8.0 PARTS LIST - CABIN DOOR MODIFICATION KITS
(FOR AIRCRAFT EQUIPPED WITH P/N 412-030-300-XXX COMPOSITE DOORS)

Qty -019	Qty -021	Qty -031	Qty -032	Qty -033	Qty -035	Part Number	Description
X						D412-698-019	BEARING OVERHAUL KIT
	X					D412-698-021	REPLACEMENT SHIM KIT
		X				D412-698-031	CABIN DOOR ROLLER KIT, LH
			X			D412-698-032	CABIN DOOR ROLLER KIT, RH
				X		D412-698-033	REPLACEMENT DOOR TRACK KIT
					X	D412-698-035	DOOR HANDLE KIT
7						D3121-21	BOLT
5						D3121-241	BEARING ASSEMBLY
1						D3137-3	GUIDE
1						D3137-5	WASHER
2						D3183-045	BEARING ASSEMBLY
	3					D3238-1	SHIM
	1					D3238-3	SHIM
	2					D3238-5	SHIM
	6					D3238-11	SHIM
	2					D3238-13	SHIM
	4					D3238-15	SHIM
		1				D3121-143	BRACKET ASSEMBLY
			1			D3121-144	BRACKET ASSEMBLY
		1	1			D3137-043	BRACKET ASSEMBLY
		1				D3183-043	BRACKET ASSEMBLY
			1			D3183-044	BRACKET ASSEMBLY
		1	1	1		D3202-3	COVER
		3	3			D3674-041	BRACKET ASSEMBLY
		9	9	9		D3675-1	BRACKET
					2	D3779-041	HANDLE ASSEMBLY
					2	D3779-3	PLATE
					2	D3779-043	HANDLE ASSEMBLY
					12	AN525-832R8	SCREW
					12	AN960JD10L	WASHER
					12	MS21042L3	NUT
					12	MS24694-S58	SCREW
1						MS24694-S101	SCREW